

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59678

Wednesday, June 09, 2010 1:12:32 PM

Page 2

Item ID: D3065-041

Accept

Revision ID:

Item Name: Step Leg Assembly Hi

Start Date: 6/9/2010 Start Qty: 40.00

Required Date: 6/17/2010 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28 *[Signature]*
mf
10-6-28

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NOTE: Date & initial all entries

Picklist Print

Page 1

June 24, 2010 9:12:55 AM

Work Order ID: 59678

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 6/09/10

Required Date: 6/17/10

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No				Each	58.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				23					
					58537			23					
				WA				35					
					58210			35					
D3065-3 Step Spacer		Manufactured	No				Each	22.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				12					
					58538			12					
				WA				10					
					48113			10					
D3065-5 Step Leg		Manufactured	No				Each	0.0000	2	80			
								B59851					
D3065-7 Step Spacer		Manufactured	No				Each	55.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				55					
					57217			12					
					59854			43					

Picklist Print

June 24, 2010 9:12:55 AM

Work Order ID: 59678

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 6/09/10

Required Date: 6/17/10

Start Qty: 40.00

Required Qty: 40.00

M6061T6S.063

Purchased

No

sf

121.1500

4.54



6061-T6 .063 Sheet



Location

Loc Qty

Loc Code

MAT21

121.15

113608

121.15

Each

1,535.000

30

1200

MS20470AD4-4

Purchased

No



Rivet, Universal Head



Location

Loc Qty

Loc Code

ST319

122

112314

30

113368

92

ST321

1413

114761

1413

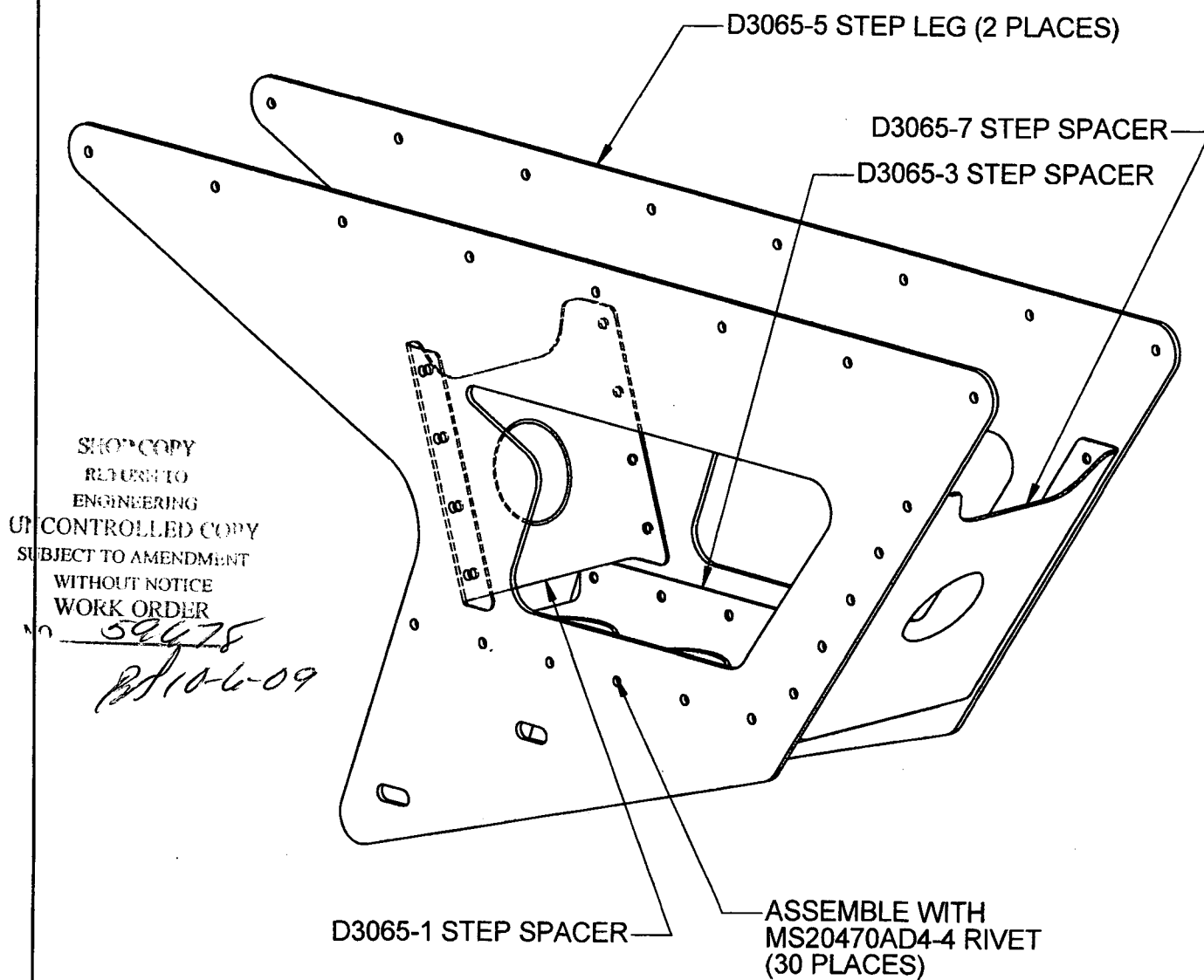
✓

6/10/06/28

1200

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20* *[Signature]***D3065-041 STEP LEG ASSEMBLY****COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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Dart Aerospace Ltd

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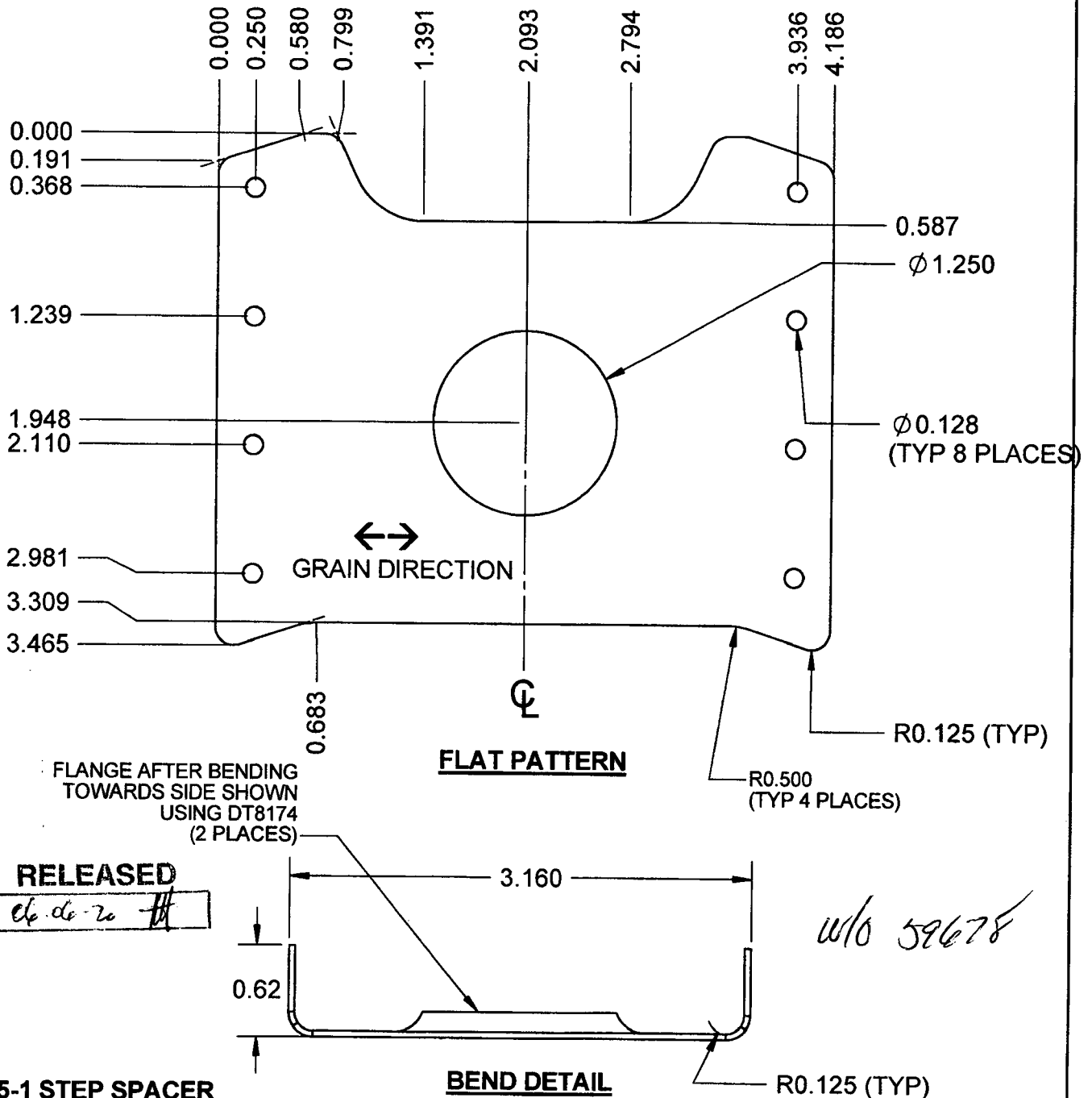
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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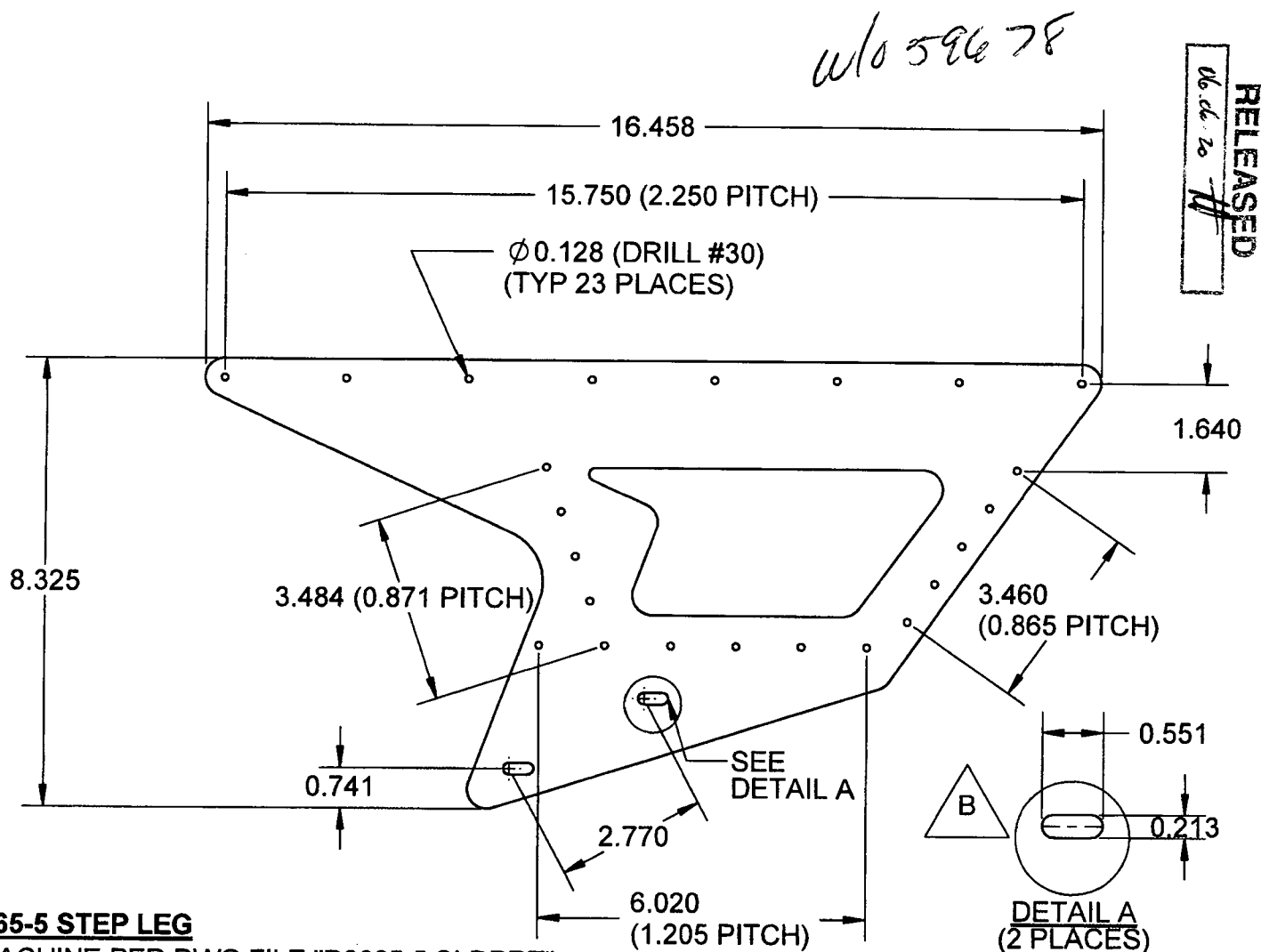
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DESIGN	<i>CP</i>	DRAWN BY	<i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D3065	SHEET 4 OF 5
DATE	06.05.23		TITLE		SCALE
			STEP LEG ASSEMBLY		1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
 (REF DART SPEC M6061T6S.080)
 OR
 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES

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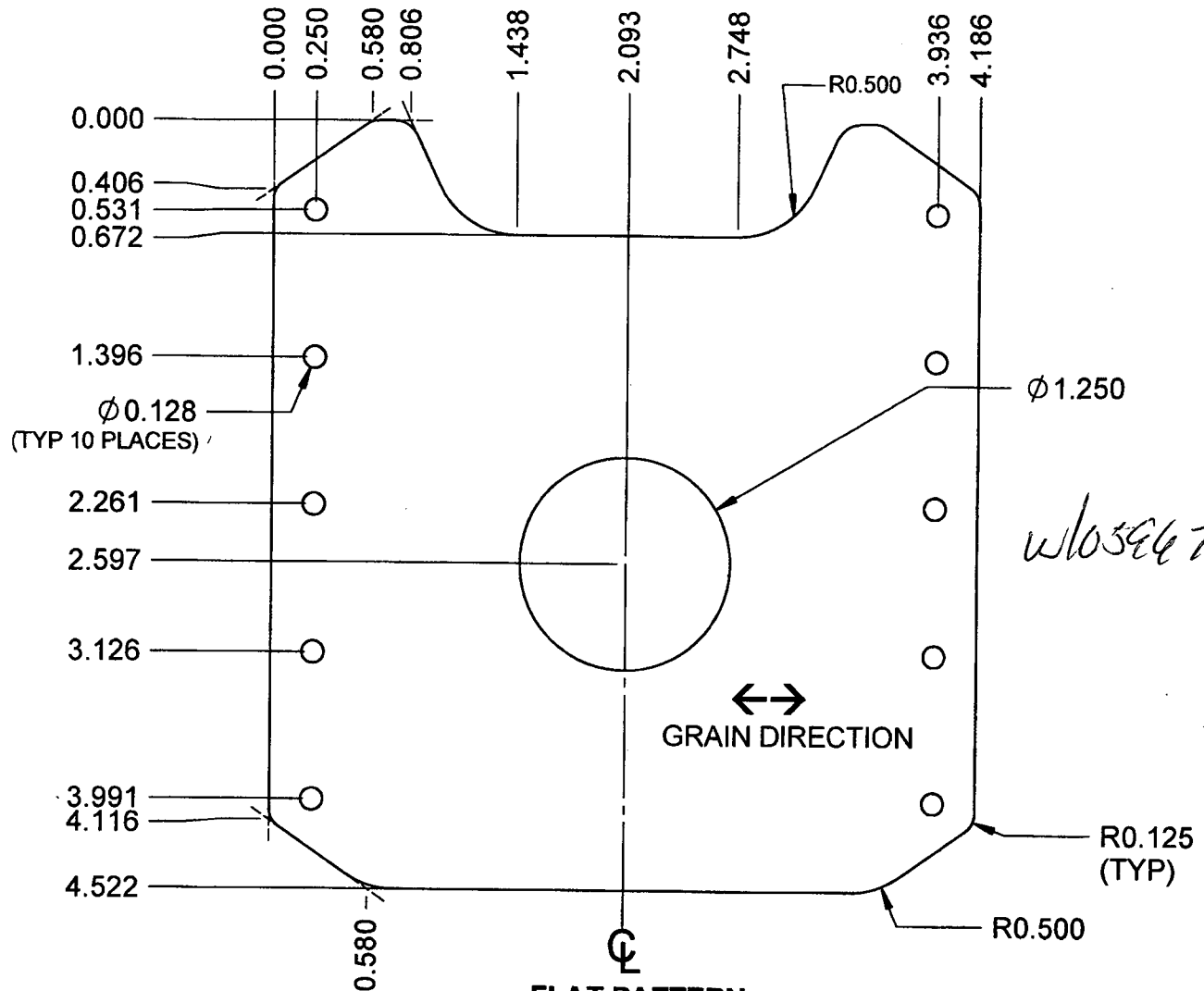
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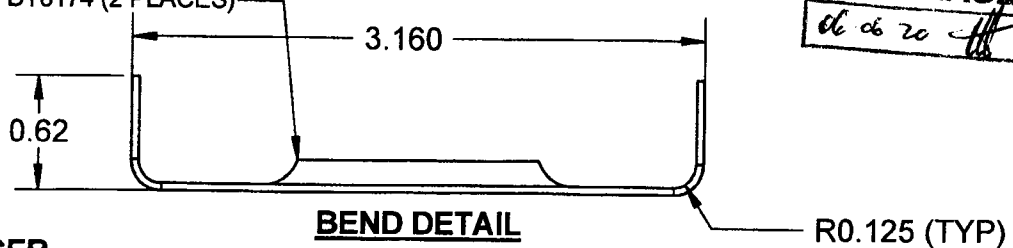
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN

RELEASED



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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